

82301

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

8

Cust Item ID:

8

Customer:

Reference:

Date:

Run Start *NR1*

Date:

Stop *NR2*

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Revision Nbr

Rev B

Pick Kit

100

Packaging

Packaging

Memo

0.00

0.00

110

0.00

110

Small Fab

Small Fab

Small Fab

Memo

0.00

1-Install Studs and Gromets as per Dwg D32453-Bond Gasket using 3M
ADHESIVE as per Dwg D3245A/R 3M 1300/1300L ADHESIVE
Batch: 17120954

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82301

March-28-12 2:31:49 PM

82301

Page 2

Item ID: D3245-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 28/03/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 11/04/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
130									
Packaging	Memo	0.00				8X			SP 1261
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/6/14 MF
 12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-28-12 2:31:54 PM

Page 1

Work Order ID: 82301

82301

Parent Item: D3245-043

D3245-043

Parent Item Name: Door Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-09-11 JLM Verified By:EC
IPP Rev:b ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

127H-35		Purchased	No			100	Each	80.0000	8	64			
---------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

127H-35

HALF GROMMET

**

Location

Loc Qty

Loc Code

GA

72

119545

72

ST398

8

117203

5

118261

3

2351-20-009-C3Y

Purchased

No

110

Each

50.0000

8

64

2351-20-009-C3Y

STUD

**

Location

Loc Qty

Loc Code

ST400

50

117358

4

120595

40

15447

6

D3245-3

Manufactured

No

110

Each

11.0000

1

8

D3245-3

Door

**

Location

Loc Qty

Loc Code

GA

11

77821

5

78626

6

EP 12/06/01

M12/827

64

EP 12/06/01

M12/499

64

EP 12/05/14

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 82301

82301

Parent Item: D3245-043

D3245-043

Parent Item Name: Door Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 8.00

Required Qty: 8.00

D3245-7

Manufactured No

110

Each

6.0000

1

8

D3245-7

**

Gasket

Location

Loc Qty

Loc Code

ST233B

6

78624

6

Handwritten:
28/05/14
B83197
22

March-28-12 2:31:54 PM

Shop Packet Print

Page 2

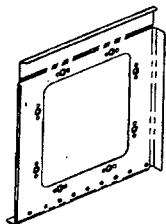
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

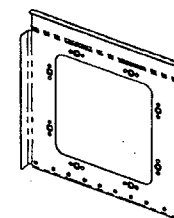
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

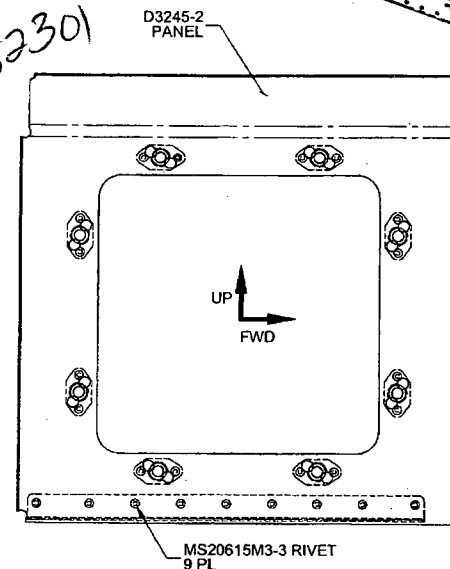
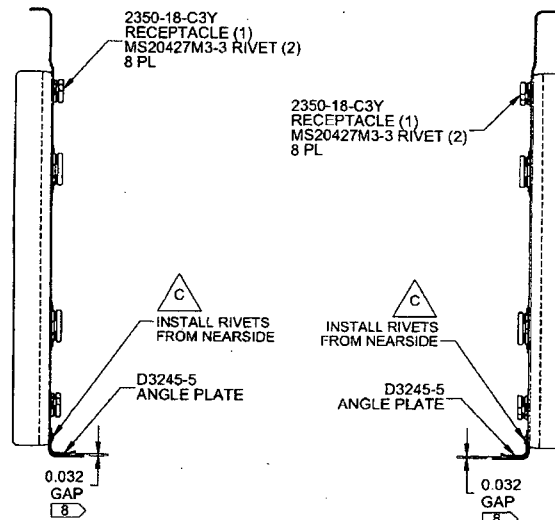
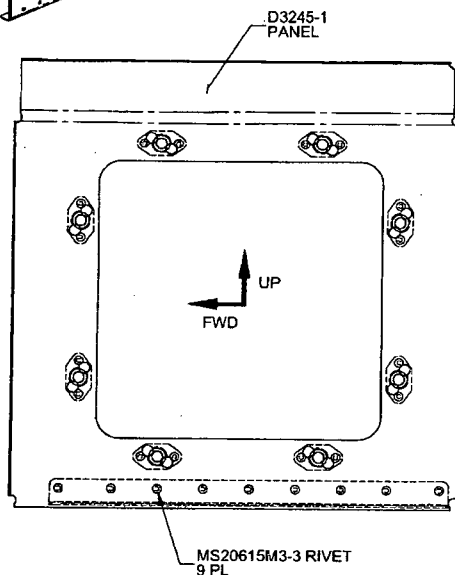
NOTE: Date & initial all entries



D3245-041 ACCESS PANEL ASSY (LH)



D3245-042 ACCESS PANEL ASSY (RH)



QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSY (LH)
	X	D3245-042	ACCESS PANEL ASSY (RH)
1		D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.83 lbs
- 8) TEMPORARILY INSERT A.0.032" GAUGE PLATE PRIOR TO RIVETING D3245-5 TO PANEL

C		ADDED NOTE & SHEET 1, SPECIFIED RIVET ORIENTATION (B4-1, B5-1) CHANGED 1/4-TURN STUD FROM 2351-20-009-C3Y TO 2351-20-012-C3Y (D5-2). HOLE SIZE WAS 0.098, 9 PLACES (D6-6). HOLE SIZE WAS 0.219, 8 PLACES (D7-5). REF: PAR 12-165.		RP	12.04.11
B		REMOVE Ø0.204 HOLES FROM D3245-1/1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN PINS TO GASKETS & REFORMAT DRAWING		MB	07.10.02
A		NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION			BY	DATE
DESIGN	RF			DART AEROSPACE LTD	
DRAWN	MB			HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.			DRAWING NO. D3245	
MFG. APPR.	[Signature]			SHEET 1 OF 7	
APPROVED	[Signature]			TITLE ACCESS PANEL ASSY	
DE APPR.	[Signature]			SCALE	
DATE	12.04.11			NTS	

RELEASED 2012-05-07

D3245-3 DOOR

2351-20-012-C3Y STUD
127H-35 GROMMET
8 PL



8.00
REF

INSTALL D3245-7
GASKET ON THIS SIDE
6

8.00 REF

D3245-7 GASKET
REF

D3245-043 DOOR ASSY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	127H-35	GROMMET
8	2351-20-012-C3Y	STUD



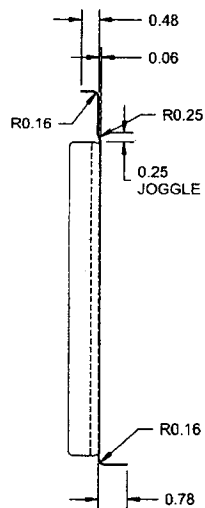
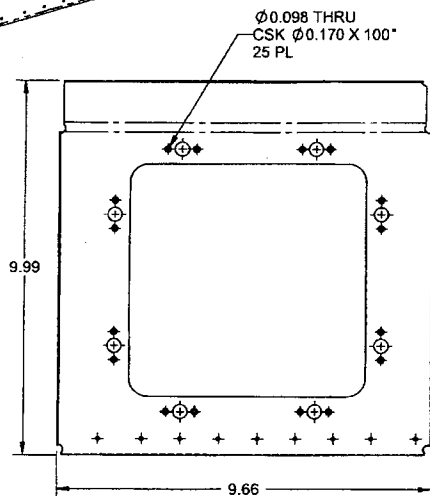
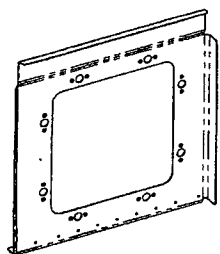
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" PER QSI 044 METHOD 6.1
- 9) WEIGHT: 0.72 lbs

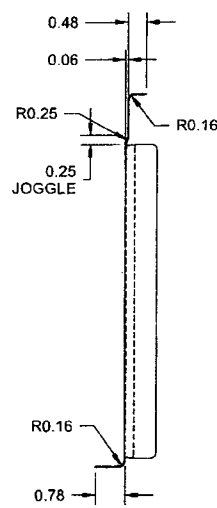
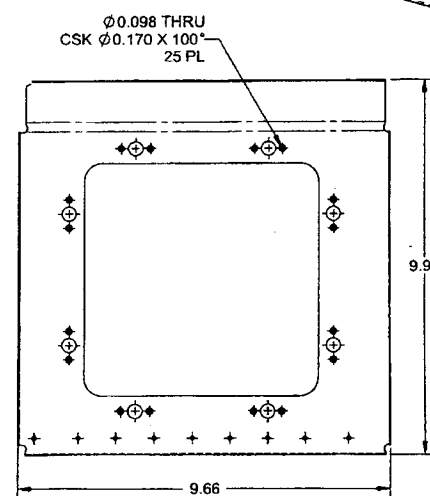
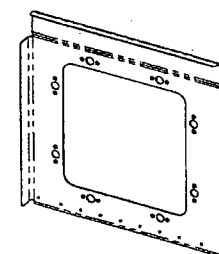
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DRAWN	MB		
CHECKED	AP	DRAWING NO. D3245	REV. C
MFG. APPR.			SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
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2012-05-07

#82301



D3245-1 PANEL (LH)



D3245-2 PANEL (RH)

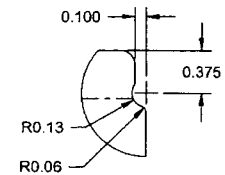
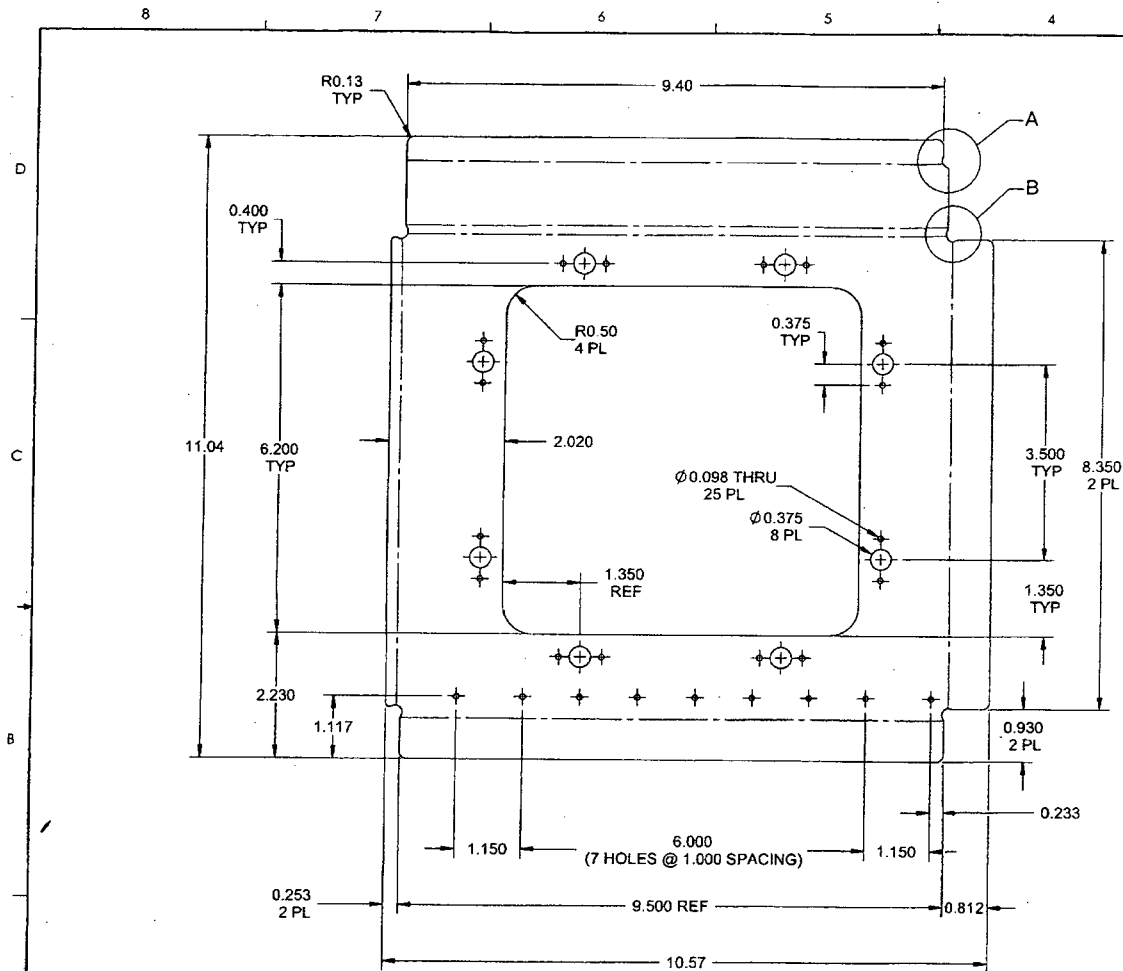
NOTES:

- 1) MATERIAL: MAKE FROM D3245-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

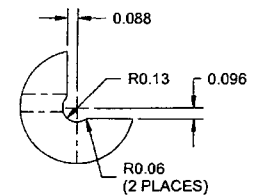
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2012-05-07

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CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 3 OF 7
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DETAIL A: RELIEF
SCALE 1:1



DETAIL B: RELIEF
TYP. 4 PL
SCALE 1:1

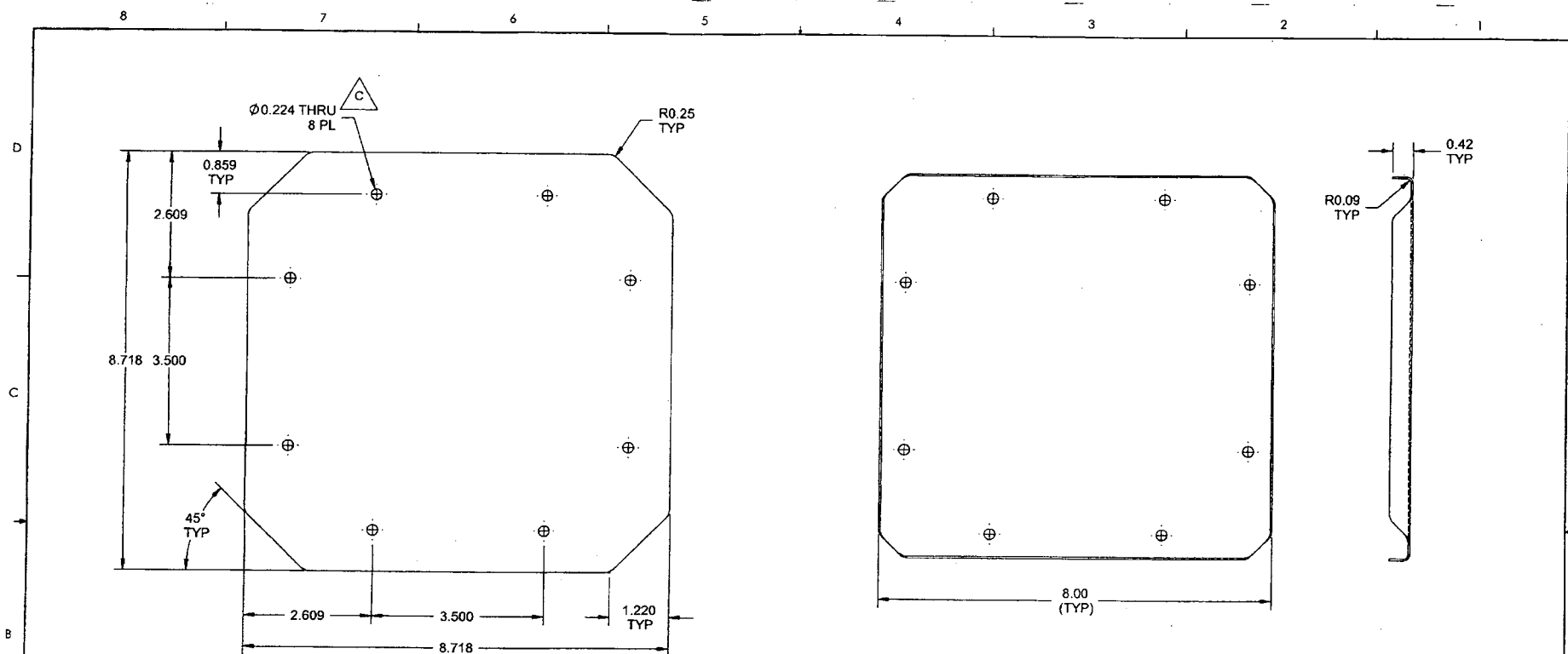
#82301

RELEASED
2012-05-07
WNP

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.70 lbs

D3245-1F PANEL FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	AP	DRAWING NO. D3245	REV. C
MFG. APPR.	WNP	SHEET 4 OF 7	
APPROVED	WNP	TITLE ACCESS PANEL ASSY	SCALE NTS
DE APPR.	WNP	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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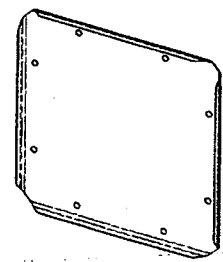
D3245-3F DOOR FLAT PATTERN

**D3245-3 DOOR
(MADE FROM D3245-3F)**

82301

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2012-05-07

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.66 lbs



DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.		D3245	SHEET 5 OF 7
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSY	NTS
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8 7 6 5 4 3 2 1

D

D

C

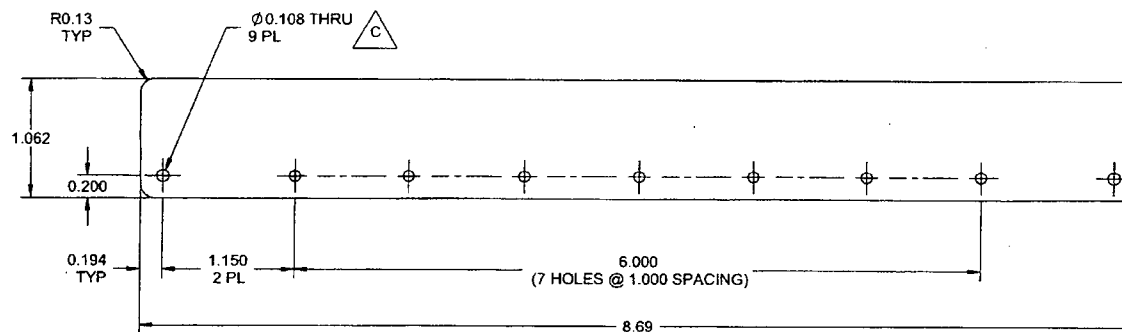
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B

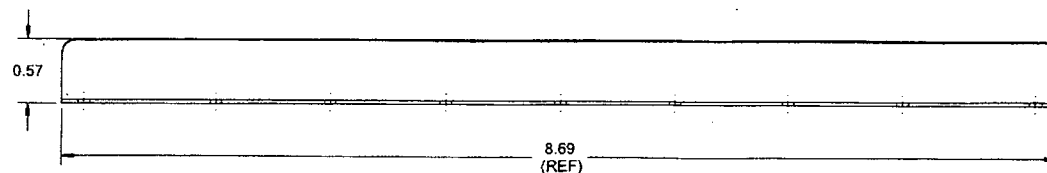
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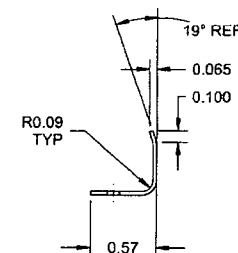
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D3245-5F FLAT PATTERN



D3245-5 ANGLE PLATE
(MAKE FROM D3245-5F)



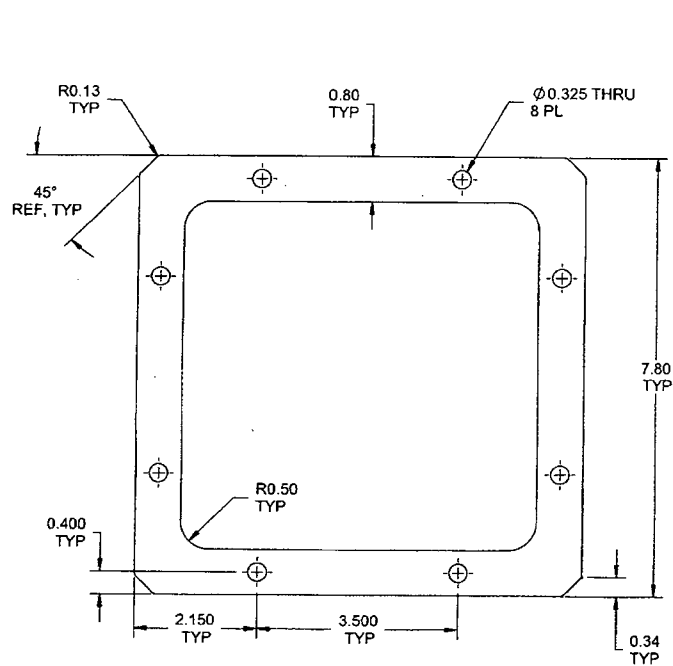
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.032 THICK, ANNEALED, 2B FINISH, PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 (REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

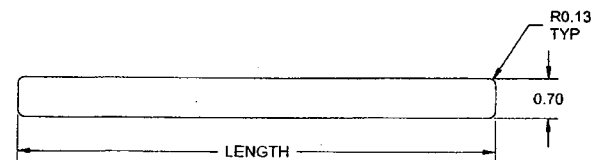
62301

REL. USED
R 2012-07-07
JAD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AD	DRAWING NO.	REV. C
MFG. APPR.	FD	D3245	SHEET 6 OF 7
APPROVED	JAD	TITLE	SCALE
DE APPR.	JAD	ACCESS PANEL ASSY	NTS
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D3245-7 GASKET



D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
(REF. DART SPEC. MDURAS.035)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MB</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MB</i>	D3245	SHEET 7 OF 7
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	ACCESS PANEL ASSY	NTS
DATE	12.04.11	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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#82301